

54270 DeRow

Work Order ID 53914



Page 1

November 23, 2009 2:45:08 PM

Item ID: D2841-041

Accept

Revision ID: B

Item Name: Step Assembly, 206 Float

Start Date: 23/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 23/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *09/11/23*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2841	Rev B

100 Large Fab 0.00

Large Fab Memo 0.00

Large Fab 1-Cut D2841-1 using D2622 extrusion as per Dwg D2841 □ 2-Drill extrusion per drawing D2841 using Jig DT 8265 □ 3-Deburr and bevel ends for welding

*109.11.24**✓ ✓*

110 QC5- Inspect part completeness to step on W/O 0.00

QC Memo 0.00

Quality Control

*→ Salu/25**+ 4 4*

120 Large Fab 0.00

Large Fab Memo 0.00

Large Fab 1-Weld end cap(AFT END ONLY) □ 2-weld lugs as per Dwg D2841 □ using Jig DT 8267 followed by DT 8268 A/R AL ROD Batch: *M111311* □ 3-Grind end cap welds flush*109.11.26**4 4*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Memo

0.00

PD 09.11.26

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

→ 861126

(x4LH) f

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

09.11.26

f f

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Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

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Work Center IDOperation
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

Nov/11/27

QC

Memo

0.00

Quality Control

170



Large Fab

0.00

4 of

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024 □2-Weld Remaining end cap as per Dwg
D2841 □A/R AL ROD Batch: M111311 □3- grind end cap
welds flush as per dwg D2841

Nov/11/27

4- Touch up with Alodine and 09/11/30

180



QC10- Inspect visual per QSI004- ground welds

0.00

=> S09/11/20

QC

Memo

0.00

Quality Control

4 of

W/O:		WORK ORDER CHANGES					
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Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

27 2011.130

QC

Memo

0.00

X444

Quality Control

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M102148.

Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:45

OVEN TEMPERATURE:

320°

FINISH TIME:

11:13

BF 09-12-01 444

210

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

WD 09/12/01

X4

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start
	QC:	Date:	SPC (Y/N):	Date:	Stop

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	HandFinishing HandFinish Hand Finishing	0.00							
	Memo	0.00							
	1-Install inserts as per Dwg D2842 □ 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 □ Batch: m 112623 (wingued/K) Si Kaflex : m 112345 exp: 10/08								
230 	QC5- Inspect part completeness to step on W/O QC Quality Control	0.00	⇒ S01n102						
	Memo	0.00							
240 	Identify as per dwg & Stock Location: Packaging Packaging	0.00							
	Memo	PPP S2159	0.00						

MMO 09/12/02 XY

XYLH

CG/12/17 4

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 23/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/12/09
MF

09-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 53914



Parent Item: D2841-041RevB



Parent Item Name: Step Assembly, 206 Float

Start Date: 23/11/2009

Required Date: 23/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L

Purchased

No

100

Each

2,604.000

16.0000

washer

Warehouse

Location

OFFSHORE

FG
103585

100
100

Main Warehouse

ST
112116
112612
112933

2504
548
956
1000

D2622-120CRevC1

Manufactured

No

120

Each

95.3200

4.0000

Step Extrusion

Warehouse

Location

Main Warehouse

WA
48612
52026

95.32
11.62
83.7

X10 MD 09/11/02

10.11.24

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Comments:

Start Qty: 4.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2734RevC



Manufactured

No

120

Each

39.0000

8.0000



SL 09.11.26

Step End Plate

WarehouseLocation

Main Warehouse

ST

Loc Qty

39

43535

48110

37

2

37

Loc Code

4

D3464-1RevA



Manufactured

No

120

Each

32.0000

4.0000



Float Step Mounting Plate

WarehouseLocation

Main Warehouse

ST

Loc Qty

32

37348

44607

24

8

24

Loc Code

4

D3464-3RevA



Manufactured

No

120

Each

27.0000

4.0000



Float Step Mounting Plate

WarehouseLocation

Main Warehouse

ST

Loc Qty

27

37349

37791

15

12

15

Loc Code

4

W/O:		WORK ORDER CHANGES					
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Required Date: 23/11/2009

Comments:

Start Qty: 4.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1329C3KB130

Purchased

No

220

Each

98.0000

16.0000

insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

111981

Loc Qty

98

98

220

Each

266.0000

16.0000

NAS1515H3L

Purchased

No

X16 MD 09/12/02

WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG

Loc Qty

40

102472

40

Main Warehouse

ST

110450
111819

226

2

224

X16 MD 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

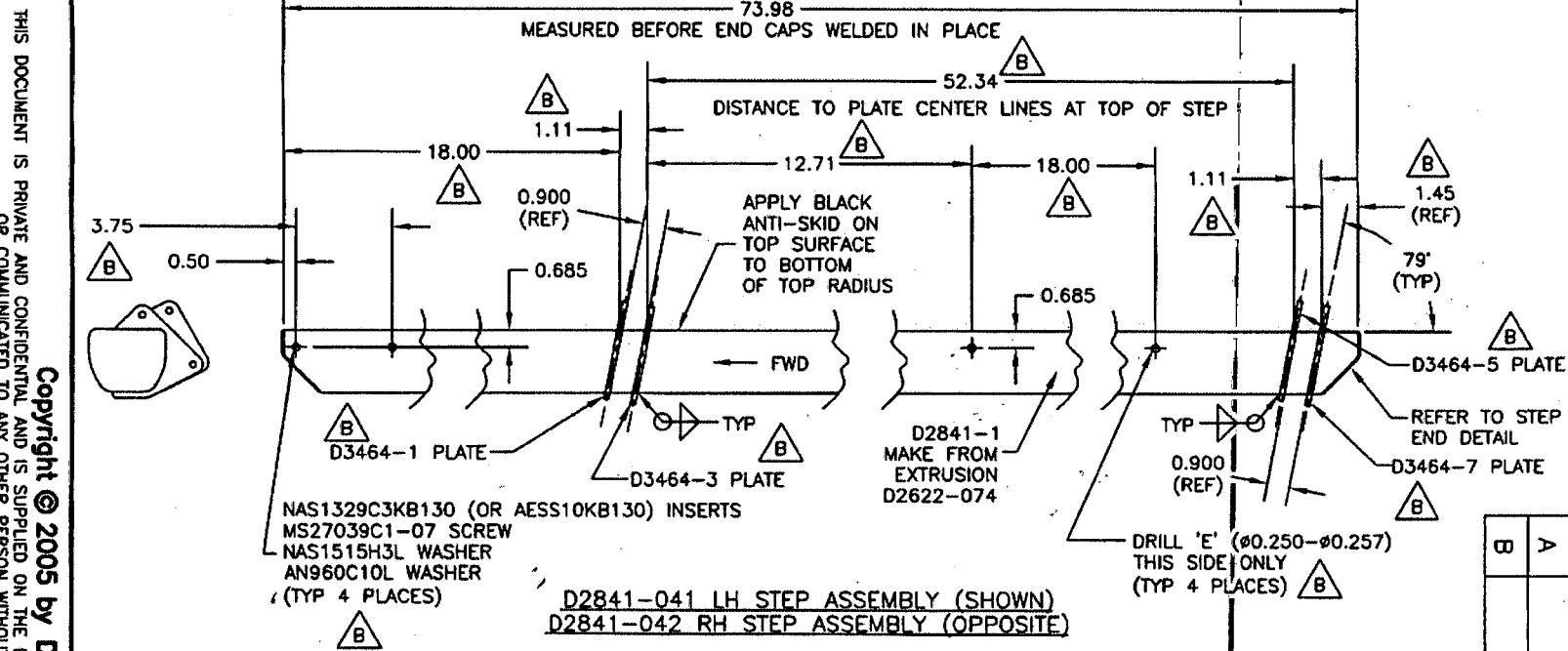
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART

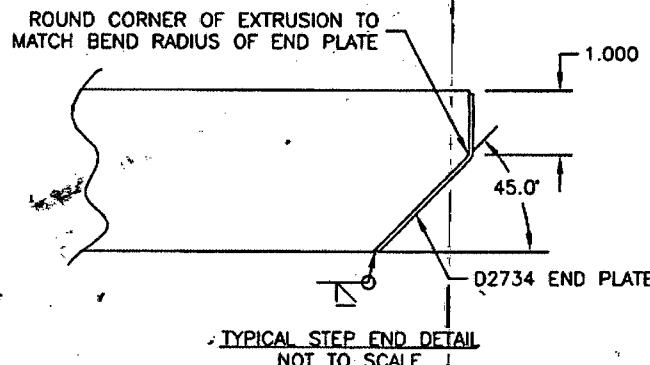


D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	.042	D2841-041	LH STEP ASSEMBLY
X	.042	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

RELEASED
05-11-14



D2841-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53214
RETURN TO
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
REV. B
SHEET 1 OF 1
NTS
SCALE